

Work Order ID 78980

Tuesday, January 17, 2012 3:00:28 PM

78980

Ship 405mm

Page 1

Item ID: D212-725-1-245

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Cam

Stop

NS2

Start Date: 1/17/2012 Start Qty: 3.00

3

Cust Item ID:

Required Date: 1/27/2012 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: *umf*

Date: *12-01-17* Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D212-725-1

G-PRELIM

100

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 3.250" long

29 12-1-24

3 4

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio FA844 and DWG

Folio rev: *HA*

Dwg Rev: *HA*

Deburr as per Dwg

29 12-1-24

3 4

C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

130

0.00

130

Mill Conv

Memo

0.00

Conventional Milling Machine

Drill & tap as per Dwg

140

QC2- Inspect parts off machine FAI/FAIB

0.00

140

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC8- Inspect parts - second check

0.00

150

QC

Memo

0.00

Quality Control

Paul 12-01-25

3 8

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

3 BL 12-1-25

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

3 of 34 n/a 1/25
counted

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

Tuesday, January 17, 2012 3:00:28 PM

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Accept

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Cust Item ID:

Required Date: 1/27/2012 Req'd Qty: 3.00 ***3***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

180

Small Fab

Memo

Small Fab

Insert Helicoil as per Dwg

0.00

0.00

190

190

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

200

200

Packaging

Packaging

Identify as per dwg & Stock Location: **382**

Memo

0.00

0.00

3(x3)12/1/2011 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date: 1/27/2012 Req'd Qty: 3.00 ***3***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

12/1/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Tuesday, January 17, 2012 3:00:27 PM

Page 1

Work Order ID: 78980

Parent Item: D212-725-1-245

Parent Item Name: Cam

Start Date: 1/17/2012

Required Date: 1/27/2012

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21209F1-15 HELI COIL		Purchased	No			160	Each	2.0000	2	6			

M6061T6B0.625X02.500

6061-T6 Bar-.625 x 2.50

Purchased

No

Location

ST304

Loc Qty

2

Loc Code

104537

2

120308

(6x)

100

f

0.5000

0.3

0.9473684

FF 02-01-25
12-01-23

Location

MAT002

Loc Qty

0.5

Loc Code

114351

0.5

M 17 0377

.750 x 2.50
Jan 12-01-21
This Butel
only

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

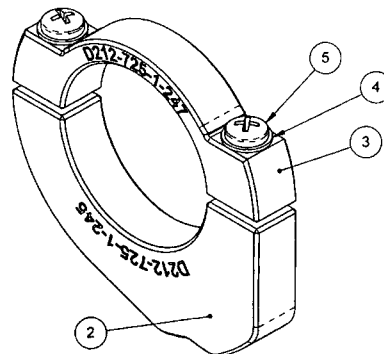
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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ITEM	QTY .947	PART NUMBER	DESCRIPTION
1	X	D212-725-1-947	CAM ASSEMBLY
2	1	D212-725-1-245	CAM BASE ASSEMBLY
3	1	D212-725-1-247	RETAINER
4	2	NAS1149D0332J	WASHER
5	2	MS27039-1-15	SCREW



D212-725-1-947 CAM ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 0.21 lbs

A	NEW ISSUE	RF	11.02.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4163	SHEET 1 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CAM ASSEMBLY	NTS
DATE	11.02.24	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

RELEASED
2011-08-23
WMD

78980

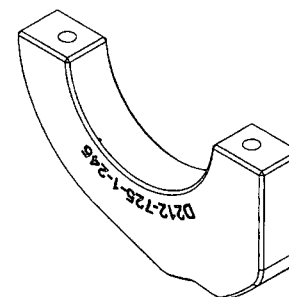
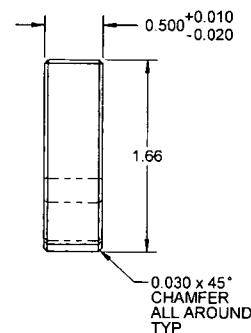
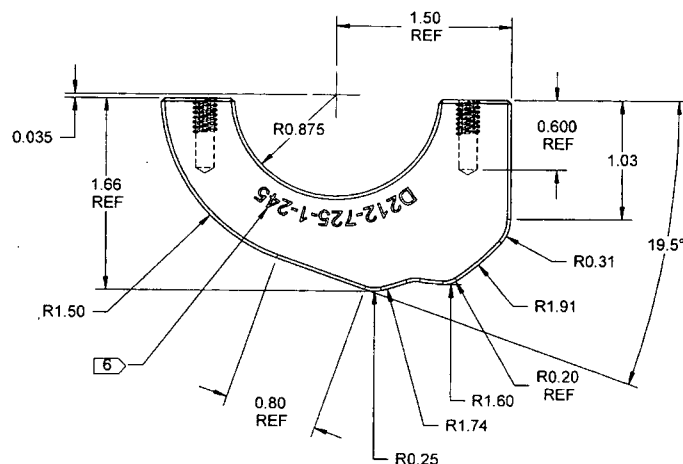
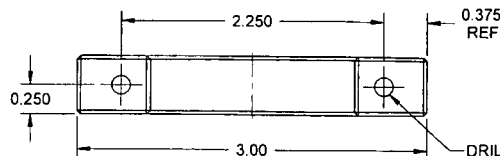
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NOTE: Date & initial all entries



D212-725-1-245 CAM BASE ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO ASSEMBLY
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 AS SHOWN
- 7) WEIGHT: 0.14 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4163	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CAM ASSEMBLY	NTS
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2011-08-23

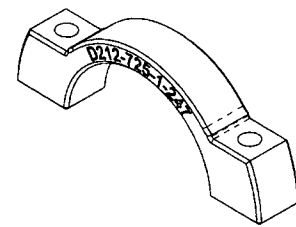
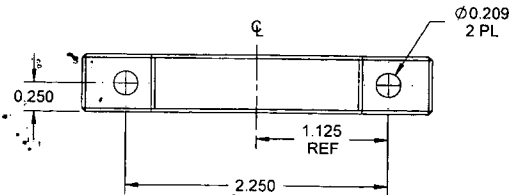
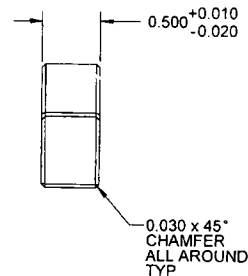
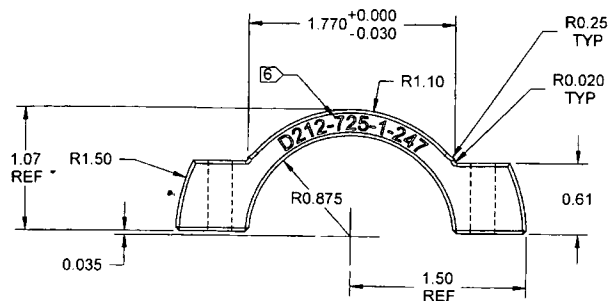
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



78980

D212-725-1-247 RETAINER

RELEASED
2011-08-25

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 AS SHOWN
- 7) WEIGHT: 0.05 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4163	REV. A
MFG. APPR.	RF	SHEET 3 OF 3	
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CAM ASSEMBLY	NTS
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